January-17-13 1:17:27 PM

Page 1

Item ID: D2221 Accept *N900040100* Setup Start Revision ID: Item Name: 350 Basket Base Start Date: 1/17/13 Start Qty: 1.00 Cust Item ID: Required Date: 1/25/13 Rea'd Otv: 1.00 Customer Reference: Run Process Plan: HLJ Date: 13-01-17 Tooling: Approvals: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Reject Tool# Plan Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Number Stamp Otv Draw Nhr **Revision Nbr** D2221 Rev H 100 0.00 Large Fab *100* Large Fab 0.00 Memo Large Fab 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: 4122357 ***PLEASE NOTE*** IF MAKING -041A OR -043A · DRILL HOLES FOR GAS SPRING IN D3825-041 AS PER DSI 9473 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 *110* 13.03.12 QC 0.00 Memo Quality Control

						•					DQA:	Date	:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFOR	MANCE / UPD	ATE	•			
											QA Closed:	Date	•	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Actio	on	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector	
Doc/Data		ļ												
Equip/Tooling														
Operator														
Material											·			
Setup														
Other														
Process					:									
Supplier														
Training							1							
Unapproved												-		
						F	AUL	T CATE	GORY					
Landi	ng (Gear				General		_			_			
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct [Weld	
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Ui	nclear	Part Lost/Mi	issing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	enance		Part Moved	_	_	
	Heat Treat					Countersink		Mislabe	eled		Positioned Wrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

95998

Page 2

Item ID: D2221 Accept *N900040100* Setup Start Revision ID: Item Name: 350 Basket Base Start Date: 1/17/13 Start Otv: 1.00 Cust Item ID: Required Date: 1/25/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Otv Qty Stamp Number 120 QC6- Inspect dimensions to drawing 0.00 *120* 13-03-12 OC. 0.00 Memo Quality Control 125 Pressure Wash per OSi005 4.3 0.00 *105* HandFinish Memo 0.00 Hand Finishing

January-17-13 1:17:27 PM

												DQA:	Date:	:					
NCR:	/es	/ No					WORK ORDER NON-C	100	NFOR	MANCE / UP	DATE	·							
_												QA Closed:	Water Jet Engineering Quality Other Supplier						
Nork Orde	er:						DISPOSITION				AGAINST D	EPARTMENT	PROCESS						
Part 1	- - ۱o.						Rework Scrap Use-as-is			Skid-tube Machining Moforming	Crosstube Small Fab Finishing	⊣	d. Eng. Coor.	Quality					
NCR I	No.						Work Order Update]	incii	Large Fab	Composite] ((C))	· · · · · ·						
Root					Desc	rip	tion of work order update	1	nitial	Ac	tion	Sign &							
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector					
oc/Data																			
quip/Tooling	Ш																		
perator	Ш																		
1aterial	Щ							1					٠						
etup 🥍 🧳																			
ther 🚱 🕻																			
rocess								İ											
upplier																			
raining																			
napproved								<u> </u>											
							F.	AUL	T CATE	GORY									
Landi	ng G	iear					General							·					
	Ш	Bending				╝	Bend		Grain			Ovalized		Pressure/Forced					
		Centre No	t Concer	ntric to	o/s		BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure					
		Cracks				╝	Broken/Damaged		Inspect	ion Incomplete		Part Incorred	ct	Weld					
		Crushed/C	Crimped.				Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled					
		Cuffs					Contamination		Mainte	enance		Part Moved	-	-					
		Heat Trea	t		Γ		Countersink		Mislabe	eled		Positioned V	Vrong						
		Inspection	Strip in	Tube	Γ		Cut Too Short		Misrea	d		Power Loss/	Surge	Other					
		Ripples in	Bend				Drill Holes		Offset		<u> </u>			-					
:		Torque W	aves in E	xtrusio	1 T		Drawing		Out of	Calibration		•							
		Turning Se	equence			٦	Finish		Out of	Sequence									

Outside Dimensions

Wave/Twist in Tube

95998

January-17-13 1:17:27 PM

Item ID:

D2221

Accept

N900040100

Setup Start *NIC1*

Revision ID:

Item Name: **Start Date:**

350 Basket Base

1/17/13

Start Qty: 1.00 Req'd Oty: 1.00 *1* *1*

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 1/25/13

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Run

Date:

Sequence ID/ Work Center ID

m 124245

Operation **Description**

Set Up/ **Run Hours**

Tool # Plan Tool ID

Accept Qty

Code

Reject

Reject Insp.

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Qty

Number Stamp

130

Powdercoat Powder Coating

Memo

0.00

1- Plug holes prior to

START TIME:

2ND COAT: START TIME:

OVEN TEMPERATURE:

FINISH TIME:

QC3- Inspect Part Finish

0.00

140

Memo

0.00

1 \$ B-3-20

140

Quality Control

									DQA:	, Date:						
NCR: Yes	s / No				WORK ORDER NON-	CONFOR	MANCE / UP		QA Closed: Date:							
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS						
Part No.			.,		Rework Scrap Use-as-is	1 1	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other					
NCR No.	•		-	.	Work Order Update		Large Fab	Composite		Supplier						
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &							
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector					
Doc/Data	_															
quip/Tooling																
Operator																
Material																
ietup																
Other																

			FAU	LT CATEGORY		•
Landi	ng Gear	General				_
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
9, K	Crushed/Crimped_	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
7, 4	Cuffs	Contamination		Maintenance	Part Moved	
1840	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset	 _	
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

QC

Quality Control

Memo

Page 4

January-17-13 1:17:27 PM Item ID: D2221 Accept *N900040100* Setup Start **Revision ID:** Item Name: 350 Basket Base **Start Date:** Start Qty: 1.00 1/17/13 Cust Item ID: Required Date: 1/25/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Stop QC: Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 150 Identify as per dwg & Stock Location 350-6007-041 *150* Packaging 0.00 Memo Packaging 160 QC2i- Final Inspection - Work Order Release 0.00 *160*

0.00

MLJ 13 03-20

NCR:	Yes	/	No	

												DQA:	Date	:
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UPDATE			_	
						_						QA Closed:	Date	:
Vork Ord	er:						DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Part l					·····		Rework Scrap		1	Skid-tube Crosstub Machining Small Fa	b	-1	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	No.			•			Use-as-is Work Order Update			noforming Finishir Large Fab Composit	_	Rec/Stor	re/Packaging Supplier	Other
Root					Desc	crip	otion of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		•	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
oc/Data														
uip/Tooling]								,	
perator														
aterial							•							
tup														
ther								1						
ocess					1			İ						
ıpplier								İ						
aining														
napproved														
							F/	AUL	T CATE	GORY				
Landi	ng (Gear			_		General		-	•		_	_	<u></u>
		Bending			L		Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	tric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks			L		Broken/Damaged		Inspecti	on Incomplete	L	Part Incorre	ct	Weld
	L	Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs					Contamination		Mainte	nance		Part Moved		
	_	Heat Trea	t				Countersink		Mislabe	led		Positioned V	Vrong	
		Inspection	n Strip in	Tube			Cut Too Short		Misread	t		Power Loss/	'Surge	Other
		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n [Drawing		Out of (Calibration				
		Turning Se	equence				Finish		Out of	equence				

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-17-13 1:17:31 PM

Work Order ID: 95998

95998

Parent Item:

D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 1/17/13

Required Date: 1/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM

IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC

IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC

IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC

IPP Rev:N

10.06.29 added pressure wash DD verf.EC

	2.00.27 added pre	ssure wash DD V	CH.EC									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D2221-1		Manufactured	No	- 		100	Each	13.0000	1	1		
D2221-1									** I	3 908	56 1	L 13.03.06
				Location	<u>1</u>	<u>Loc</u>	<u>Oty</u>	Loc Code				
				WA005			13				•	
					86847		Ī			·	_	
					86848		2				_	
D0001 5					90856		10		_		_	
D2221-5		Manufactured	No			100	Each	9.0000	2	2		
D2221-5									** 1	3908	40 -	Dx St 13.03.0
				Location	<u>1</u>	<u>Loc</u>	<u>Qty</u>	Loc Code				
				WA004			7					
					90840		7				_	
				WA006			2				_	
					67117		2				_	
D2221-7		Manufactured	No			100	Each	6.0000	1	1	_	
D2221-7									** =	B 89.	398	W13.03.06
				Location	<u>l</u>	Loc	<u>Oty</u>	Loc Code				
				WA004			6					
					89398		6				_	

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	ANCE / UPE	DATE			
											QA Closed:	Date	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		្រ Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						F	AUL	LT CATE	GORY		· · · · · · · · · · · · · · · · · · ·		
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped at n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/L nance led	Inclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
'		Ripples in	Reug			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-17-13 1:17:31 PM

Work Order ID: 95998

D2221

95998 *D2221*

Parent Item Name: 350 Basket Base

Parent Item:

Start Date: 1/17/13

Required Date: 1/25/13

Start Qty: 1.00

Required Qty: 1.00

D2232-3

D2232-3

Basket Hinge

Manufactured

100

Each 24.0000

389358 →2x JJ 13.03.06

Location Loc Qty Loc Code WA004 75581 2 89358 22

D2235-1

D2235-1

Basket Rib

Manufactured No

100

Each

14.0000

B88209 - 2x SH 13:03-06

Location Loc Qty Loc Code WA004 14 66895 85602 86051 89100 93717 100 Each 68.0000

D2581

Mounting Bracket

D2581

Manufactured

B92871 +2x M 13-03 06

Location	Loc Qty	Loc Code	
WA004	68		
70766	2		
81253	1		
82506	2		
83230	3		
85452	2		
86367	23		
87706	2		
88574	10		
92871	23		

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE		_			
_											Q/	A Closed:	Da	te:	
Work Ord	er.					DISPOSITION				AGAINST D	EPA	RTMENT/	PROCESS		
Work Ord	٠٠.					Rework	1		Skid-tube	Crosstube	1		Water Jet	\Box	Engineering
Part	No.					Scrap	1		Machining	Small Fab	1	Proc	l. Eng. Coor.		Quality
				•		Use-as-is]	Thern	noforming	Finishing]	Rec/Store	e/Packaging	-	Other
NCR	No.					Work Order Update			Large Fab	Composite	J		Supplier	Ш	
Root				<u> </u>	Descri	ption of work order update		nitial	Ac	tion	Τ	Sign &	··		
Cause	•	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling											Ì				
Operator							1								
Material															:
Setup				1											
Other															
Process]											
Supplier															
Training															
Unapproved									l.	·	1_				
						F	AUL	T CATE	GORY						
Land	ing (Gear				General		_		نت سن	_				
		Bending				Bend	L	Grain			_]o	valized		L	Pressure/Forced
		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		_]o	ver/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Pa	art Incorrec	:t		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear 🗀	Pa	art Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration

Outside Dimensions

Out of Sequence

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-17-13 1:17:32 PM

Work Order ID: 95998

95998 *D2221*

Parent Item:

D2221

Parent Item Name: 350 Basket Base

Start Date: 1/17/13 Start Qty: 1.00

Required Date: 1/25/13

Required Oty: 1.00

D3442-1

Manufactured No

Manufactured

Manufactured

100

Each

Loc Qty

Loc Qty

18.0000

B90017 -DV.

Sy 13.03.06

D3825-041

D3826-041

D3827-041

Rib Assembly (Basket End)

Manufactured

Location

Location

WA004

86720

90017

100

6 Each

18

12

4.0000

Loc Code

2

**

**

**

B89450 +2,

WA004

No

No

4 89449 4 100 Each

Loc Code

SH 13.03.06

10.0000 2

Rib / Gusset Assembly

Location WA004

90838

Loc Qty

Loc Code

1390838 > JV

B90866 St 13.03.06

Rib Assembly (Inboard)

No

100

10 Each

10

9.0000

Location Loc Qty Loc Code WA005 87589 90866 6 95286 2

NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE					
						-						QA Closed:	D	ate:	
Work Ord	er.					DISPOSITION				AGAINST D	ΕF	PARTMENT	/PROCESS		
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		ľ	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor e/Packagin Supplie	r	Engineering Quality Other
						`	. i								
Root						ption of work order update	1	Initial		tion		Sign &	. يشت		
Cause	1	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desci	ription	4	Date	Verificati	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
						F	ΑUI	LT CATE	GORY						
Land	ing (Gear Bending			···	General Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Concei	ntric to (o/s	BOM/Route Broken/Damaged	F	Hardwa	re ion Incomplete	-		Over/Under Part Incorre			Temperature/Cure
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	_	Part Lost/M			Wrong Stock Pulled
	<u> </u>	Cuffs			<u> </u>	Contamination	\vdash	Mainte		<u> </u>		Part Moved			
	<u></u>	Heat Trea			<u> </u>	Countersink	<u> </u>	Mislabe		<u> </u>		Positioned \	•	_	٦ .
	<u></u>	Inspectio	•	Tube	<u> </u>	Cut Too Short	<u> </u>	Misread	d	L		Power Loss/	Surge	L	Other
l	1	Ripples in	n Bend			Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-17-13 1:17:32 PM

Work Order ID: 95998

D2221

95998 *D2221*

Parent Item:

Parent Item Name: 350 Basket Base

Start Date: 1/17/13

Required Date: 1/25/13

Start Qty: 1.00

Required Oty: 1.00

D3832-1

D3832-1

Mesh (Base)

D3833-1

Mesh (Base End Face)

Manufactured No

Manufactured

100

Each 2.0000

**

13.03-11

Location

No

WA007

Loc Otv 1 100 Each

Loc Code

20.0000

**

B92602-201 JJ 13.03.06

Location Loc Qty Loc Code WA007 20 77521 81259 89208 89766 4 92602 10

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		
			OA Closed:	Date:

											QA Closed:	Date	
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No				Scrap Machining Small Fab Use-as-is Thermoforming Finishing		Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other				
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	or Non-conformance		Ch	ief Eng Description		Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													·
Process													
Supplier			}										
Training													
Unapproved	لبا		l	İ			<u> </u>						
FAULT CATEGORY													
Landing Gear General													
	<u> </u>	Bending				Bend	Grain				Ovalized	<u> </u>	Pressure/Forced
	Щ	Centre Not Concentric to O/S			o/s	BOM/Route		Hardware		-	Over/Under	<u> </u>	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspection Incomplete		_	Part Incorre	_	Weld
	Ш	Crushed/Crimped.			_	Burrs	<u> </u>	Instructions Incomplete/Unclear		/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Щ	Cuffs			<u> </u>	Contamination		Maintenance		Part Moved			
	\vdash	Heat Treat			\vdash	Countersink			-		Positioned Wrong		¬
	Inspection Strip in Tube			Tube	Cut Too Short	Misread		d	L	Power Loss/	Surge	Other	
	Ripples in Bend				Drill Holes	Offs							
		Torque W			n	Drawing	_	1	Calibration				
	Turning Sequence				<u> </u>	Finish	\vdash	Out of Sequence					
	Wave/Twist in Tube			oe -	ı	Folio	1	Outside Dimensions					

D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

े. H¹ः	ITEM	QTY	P/N	DESCRIPTION .
de j	1	Х	D2221	BASKET BASE ASSEMBLY (AS350)
}	2	1	D2221-1	RIB
-	3	2	D2221-5	RIB
1	4	1	D2221-7	RIB
	5	2	D2232-3	BASKET HINGE
	6	2	D2235-1	RIB
	7	2	D2581	MOUNTING BRACKET
-	8	2	D3442-1	SHIM
ſ	9	2	D3825-041	RIB ASSY (BASKET END)
	10	2	D3826-041	RIB/GUSSET ASSY
	11	1	D3827-041	RIB ASSY (INBOARD)
	12	2	D3833-1	MESH, BASE END FACE
	13	1	D3832-1	MESH (BASE)

UNCON SUBJECT

SI

13-0×17 RE/1/18/18

н	REVISED PARTS LIST AND ADDED 'TIEM' COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A.A. B. B. AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL D (ZN B7-4); ADDED DWG DETAIL B (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7-F (ZN B2-4); TOL REVISED TO 2 DEC PLACES (ZN B8-3 AND ZN B4-3); D3822-6 ADDED D382-1-3/D2327-3; D3826-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3822-1 AND D3833-1. REASON: SATISFY "LEAR MANUFACTURING" PROGRAM.					
G	MATERIAL FOR -1, -3, -5, 8, -7 WAS 0,060 WALL: TOLERANCE FOR 96,00 DIM WAS +4-01 AND 55,00 DIM WAS REF (ZN 85-2), 19,62 DIM WAS +4-RRD* DIMENSION IS NOW "REF" (ZN 84-2), 19,07 E 5 TRANSFERED FROM SHI 1 TO SHI 2; SHI 2 MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT					
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID PH 05.06.07					
Ε	CHANG	E HINGE	CP	01.04.19		
D	CHANG	E LATCH	BW	96.06.21		
С	SEPAR	ATE BASKET A	KH	95.11.21		
REV.	DESCRIPTION BY DATE					
DESIGN	1	BW	DART AFROSPA	CEL	TD	

0041401	- 1	HAWKESBURY, ONTARIO, CANADA				
DRAWN	حز					
CHECKED	1/25	DRAWING NO. REV. H				
MFG. APPR.	_ W_	D2221 SHEET 1 OF 5				
APPROVED	M	TITLE SCALE				
DE APPR.	-#-	BASKET BASE ASSEMBLY (350) NTS				
DATE 08.0	9.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVED AND CONFIDENTIAL AND IS SUPPLED OF THE EXPRESS CONTROL IN A TO TO DECUSED OF A PRIVED OF CONFIDENCIAL AND TO AND OTHER PRISON, WITHOUT				

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 BIS APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING







